



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3715

Job Sheet 206316



Part No: 646.3715

Job Qty: 40 pcs

Part Name: Strut Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/20

Job Tracking No:

Due Date: 3/9/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 6 IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	40 pcs			0.17	1.44	Waterjet - Flow		m 20/02/03
120	QC 2	40 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		m 20/02/03
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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130 QC 8	40 pcs	0.00 0.00	QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
140 Outsource - 4 - Anodize	40 pcs		ATG001-VC	5
150 Packaging 2-1 - Receive - B4B	40 pcs	0.00 0.00	Packaging 2 - 1 - B4B	
			Packaging 2 - 2 - B4B	
			Packaging 2 - 3 - B4B	
			Packaging 2 - 5 - B4B	
			Packaging 2 - 4 - B4B	
			Packaging 2 - 6 - B4B	
			Packaging 2 - 7 - B4B	
			Packaging 2 - 8 - B4B	
			Packaging 2 - 9 - B4B	
			Packaging 2 - 10 - B4B	
			Packaging 2 - 11 - B4B	
			Packaging 2 - 12 - B4B	
			Packaging 2 - 13 - B4B	
			Packaging 2 - 14 - B4B	
			Packaging 2 - 15 - B4B	
			Packaging 2 - 16 - B4B	
			Packaging 2 - 17 - B4B	
			Packaging 2 - 18 - B4B	
			Packaging 2 - 19 - B4B	
			Packaging 2 - 20 - B4B	
			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	
			Packaging 2 - 26 - B4B	

DAS
40
FEB 03 2020
9:59

2020-02-10

FEB 24 2020

			Packaging 2 - 27 - B4B	
			Packaging 2 - 28 - B4B	
			Packaging 2 - 29 - B4B	
			Packaging 2 - 30 - B4B	
			Packaging 2 - 31 - B4B	
			Packaging 2 - 32 - B4B	
			Packaging 2 - 33 - B4B	
			Packaging 2 - 34 - B4B	
			Packaging 2 - 35 - B4B	
			Packaging 2 - 36 - B4B	
			Packaging 2 - 37 - B4B	
160 QC 6	40 pcs	0.00 0.00	QC 6 - 9	
			QC 6 - 68	
			QC 6 - 61	DAS
			QC 6 - 40	81
			QC 6 - 81	9-89
				APR 14 2020
190 Packaging 3-1 - Stock - B4B	40 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
200 QC 21 - SA	40 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-08
				APR 15 2020
Part Op 110 - 1-Cut as per Dwg				
Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB				
130 - QC8- Inspect parts - second check				

140 - Issue P/O to ATG : 45819 Hard Anodize, Color Black and Prime as per Dwg 646.3700
 150 - Receive & Inspect for Damage & Mat'l Certs
 190 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	1.7360 sf (.0434 ea)	110-Waterjet - Flow - 1	<u>5204169</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6S.040	2	303	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset	3Inches ± 0	3 2		<u>2.50 +1- .010 = 2.50</u>
2	Gusset	3Inches ± 0	3 2		<u>2.50 +1- .010 = 2.50</u>
3	Gusset	0Inches ± 0	0 0		<u>.040 +1- .010 = 0.39</u>

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

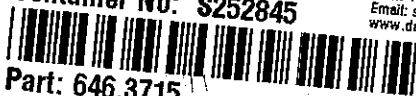
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S252845



Part: 646.3715

Job No: 206316

Serial No/Batch: S252845

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/03/20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045819



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045819

PO Date: 2/10/20

Due Date: 2/26/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2020-02-14

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206649	D5155-043	D5155 Rev B	Co-Pilot Collective Head Assembly (212/412) : Various STC's Anodize Black as per Dwg D5155 Rev. B	Firmed	-	2/26/20	2 pcs	0 pcs	2 pcs	\$6.54/pcs	\$13.08
2	206132	SWA6A-800A	SWA6A-800A Rev 4	Connector Bushing -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As Per Dwg SWA6A800 Rev. 4 - Certificate of Conformity is required	Firmed	-	2/26/20	30 pcs	0 pcs	30 pcs	\$4.09/pcs	\$122.70



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	206319	646.3812	646.3800 Rev A	Gusset Bracket : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed <i>K74</i>	-	2/26/20	24 pcs	0 pcs	24 pcs	\$6.89/pcs	\$165.36

FEB 24 2020



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	206318	646.3810	646.3800 Rev A	Bracket : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed <i>X23</i>	-	2/26/20	24 pcs	0 pcs	24 pcs	\$7.34/pcs	\$176.16
FEB 24 2020												
5	206391	RBT18591- 7	RBT18591 Rev 2B	Vise Fixture (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed <i>X6</i>	-	2/26/20	6 pcs	0 pcs	6 pcs	\$9.79/pcs	\$58.74
FEB 18 2020												



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	204984	647.0210	647.0200 Rev N/C	Rail : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N	Firmed <i>x16</i>	-	2/26/20	16 pcs	0 pcs	16 pcs	\$11.29/pcs	\$180.64 <i>KE</i>
FEB 24 2020												



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

POHB045819



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	204979	647.0111	647.0100 Rev B	Panel : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	2/26/20	16 pcs	0 pcs	16 pcs	\$40.04/pcs	\$640.64
8	206316	646.3715	646.3700 Rev A	Strut Doubler : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed X40	-	2/26/20	40 pcs	0 pcs	40 pcs	\$7.04/pcs	\$281.60

FEB 24 2020

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Grand Total: \$1,638.92

Guérin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

POHB045819



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

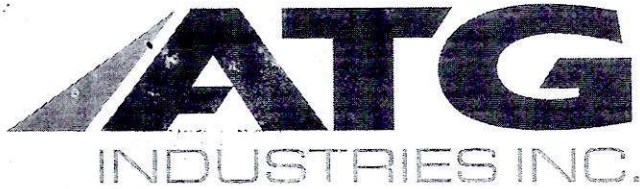
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/14/20 2:33 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919631

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
24 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot #: 5236137 Job: 26932 PO: POHB045819		Rev: A Expiry Date: 05/29/2021 Line: 3
23 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot #: 5236137 Job: 26933 PO: POHB045819		Rev: A Expiry Date: 05/29/2021 Line: 4
16 ea	Part: 647.0111 Panel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot #: 5236137 Job: 26936 PO: POHB045819		Rev: B Expiry Date: 05/29/2021 Line: 7

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FEB 21 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919631

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
40 ea	Part: 646.3715 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5236137 Job: 26937 PO: POHB045819	Rev: A	DAS 81 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: FEB 21 2020 Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED FEB 21 2020 DART AEROSPACE LTD. Made in Canada.			